

# Work Order ID 53071



Page 1

October 22, 2009 2:26:27 PM

Item ID: D130-780-044

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

*Handwritten initials*

Date: 09-10-22

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN-D130-780

B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels per PPP D130-780-044 CHG 001

*Handwritten: B/10-4-21*

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*Handwritten: 10-03-23*

120

0.00



Small Fab

Memo

0.00

Small Fab

ASSEMBLE PER DWG

*Handwritten: B3186*  
*Handwritten: 09/10/22*

*Handwritten: 10-04-05*

**Work Order ID 53071**

October 22, 2009 2:26:27 PM



Page 2

Item ID: D130-780-044

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	810405			④			
140  Packaging Packaging	Pick Kit  Memo	0.00 0.00				16-4-14	SP		
150  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00	8106120			④			

**Work Order ID 53071**

October 22, 2009 2:26:27 PM



Page 3

Item ID: D130-780-044

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D130-780-044

Location: \_\_\_\_\_

PPP Rev: A

10-4-2054 P

170

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10/04/21 MF 10-4-21

# Picklist Print

October 22, 2009 2:26:31 PM

Page 1

Work Order ID: 53071

Parent Item: D130-780-044RevA

Parent Item Name: Spacepod Door Assembly, RH




Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3186-4RevE 		Manufactured	No			110	Each	0.0000	1.0000			
Spacepod Door, RH												
D2464-1250RevB 		Manufactured	No			110	Each	0.0000	1.0000			
Neoprene Seal												
D3837-4RevB 		Manufactured	No			110	Each	5.0000	1.0000			
Decal												

53085

85 10-04-01

48173

85 10-04-01

86 85 10-03-23

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

5

46233

5

81

D2586RevD



Manufactured No

110

Each

107.0000 2.0000

85 10-03-23

Door Latch

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

107

23082

0

45554

1

47183

6

50213

100

355314 x2

# Picklist Print

October 22, 2009 2:26:31 PM

Work Order ID: 53071

Parent Item: D130-780-044RevA

Parent Item Name: Spacepod Door Assembly, RH


Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2585RevB  Mounting Channel		Manufactured	No			110	Each	47.0000	2.0000			

IT 10-03-23

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

4

45888

4

Main Warehouse

ST37

43

50544

4

51526

39

D2621RevB



Latch Plate, 350 Spacepod

Manufactured No

110

Each

68.0000

2.0000

IT 10-03-23

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

68

46842

68

82

# Picklist Print

October 22, 2009 2:26:31 PM

Work Order ID: 53071

Parent Item: D130-780-044RevA

Parent Item Name: Spacepod Door Assembly, RH



Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-15		Purchased	No			110	Each	180.0000	2.0000			
											BT 10-03-23	
Screw												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	180	
106903	3	
108169	4	
109321	4	
111916	69	
112794	100	

NAS1149D0363J

Purchased

No

110

Each

2.0000

2.0000



Washer

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	2	
112314	2	

M113288 x 2

# Picklist Print

October 22, 2009 2:26:32 PM

Work Order ID: 53071

Parent Item: D130-780-044RevA

Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009


Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L3		Purchased	No			110	Each	3,430.000	2.0000			
												
Nut												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3430

110844

32

111274

35

111668

863

112314

2000

112385

500

W113537 +2

RT 10-03-23

D2857-1RevB

Manufactured No

110

Each

18.0000

1.0000



Hinge Bracket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

41166

7

45788

5

50235

6

B55019 x1

RT 10-03-23

# Picklist Print

Page 5

October 22, 2009 2:26:32 PM

Work Order ID: 53071

Parent Item: D130-780-044RevA

Parent Item Name: Spacepod Door Assembly, RH


Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2857-2RevB  Hinge Bracket		Manufactured	No			110	Each	14.0000	1.0000			

25 10-03-23

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	14	
45797	14	


B55020

D2228RevB  Bracket Plate		Manufactured	No			110	Each	80.0000	2.0000			
---	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

25 10-03-23

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	80	
30679	37	
48228	43	

x4

AN526C832R10  Screw		Purchased	No			110	Each	105.0000	10.0000			
--	--	-----------	----	--	--	-----	------	----------	---------	--	--	--

25 10 03 23

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	105	
104603	105	

x 60



# Picklist Print

October 22, 2009 2:26:32 PM

Work Order ID: 53071

Parent Item: D130-780-044RevA

Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1149DN832J Purchased

No

110

Each

375.0000

12.0000



WASHER

ST 10-03-23

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

375

111193

3

111359

72

112385

300

M 114108 x 12

MS21042L08

Purchased

No

110

Each

407.0000

12.0000



Nut

ST 10-03-23

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

407

110002

24

111889

51

112243

47

112492

85

112612

100

112794

100

M 113749 x 12

# Picklist Print

October 22, 2009 2:26:32 PM

Work Order ID: 53071

Parent Item: D130-780-044RevA

Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009


Required Date: 04/11/2009

Comments:

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3557-1RevA  Bracket		Manufactured	No			110	Each	23.0000	1.0000			
---	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	23	
32647	1	
46887	7	
50283	15	


RT 10-03-23

D3554-7RevA  Ball Stud		Manufactured	No			110	Each	60.0000	1.0000			
---	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	60	
37674	60	

X 0

RT 10-03-23

NAS1149D0563J  Washer		Purchased	No			110	Each	100.0000	1.0000			
--	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	100	
112794	100	

M 113524

RT 10-03-23

# Picklist Print

October 22, 2009 2:26:32 PM

Work Order ID: 53071

Parent Item: D130-780-044RevA

Parent Item Name: Spacepod Door Assembly, RH


Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3015-3RevB  Locknut		Manufactured	No			110	Each	328.0000	1.0000			

RT 10-03-23

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 128

43758 26

44446 49

48238 53

Main Warehouse

ST59 200

51711 200

AN526C832R14

Purchased

No

110

Each

937.0000

2.0000

Screw

RT 10-03-23

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 937

104916 937

x2

# Picklist Print

October 22, 2009 2:26:32 PM

Page 9

Work Order ID: 53071

Parent Item: D130-780-044RevA

Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2589RevA

Manufactured

No

140

Each

61.0000

1.0000

Keys, Key Chain, 350 Hinge

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

61

46840

21

50378

40

D3552-7RevD

Manufactured

No

140

Each

2.0000

1.0000

Door Prop

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

12

52451

12

MS27039-08-11

Purchased

No

140

Each

78.0000

2.0000

Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

78

111977

78

October 22, 2009 2:26:32 PM

Shop Packet Print

Page 9

# Picklist Print

October 22, 2009 2:26:32 PM

Work Order ID: 53071



Parent Item: D130-780-044RevA



Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1149DN832J Purchased

No

140

Each

375.0000

4.0000



WASHER

M114340 10-4-14 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

375

111193

3

111359

72

112385

300

NAS1515H3

Purchased

No

140

Each

490.0000

2.0000



Washer

10-4-14 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

490

109268

259

110397

87

111268

144

2

# Picklist Print

Page 11

October 22, 2009 2:26:32 PM

Work Order ID: 53071



Parent Item: D130-780-044RevA



Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L08 Purchased

No

140

Each

407.0000

2.0000

M114056 10-4-14

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

407

110002

24

111889

51

112243

47

112492

85

112612

100

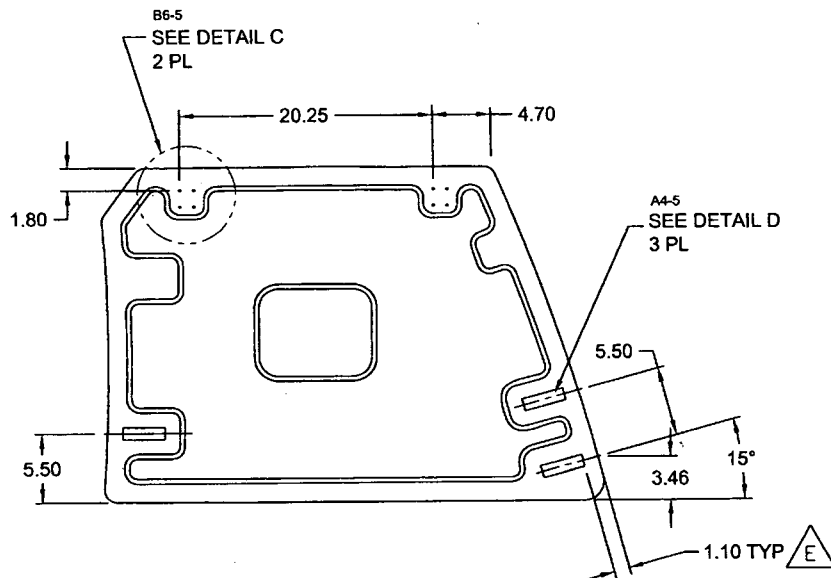
112794

100

October 22, 2009 2:26:32 PM

Shop Packet Print

Page 11

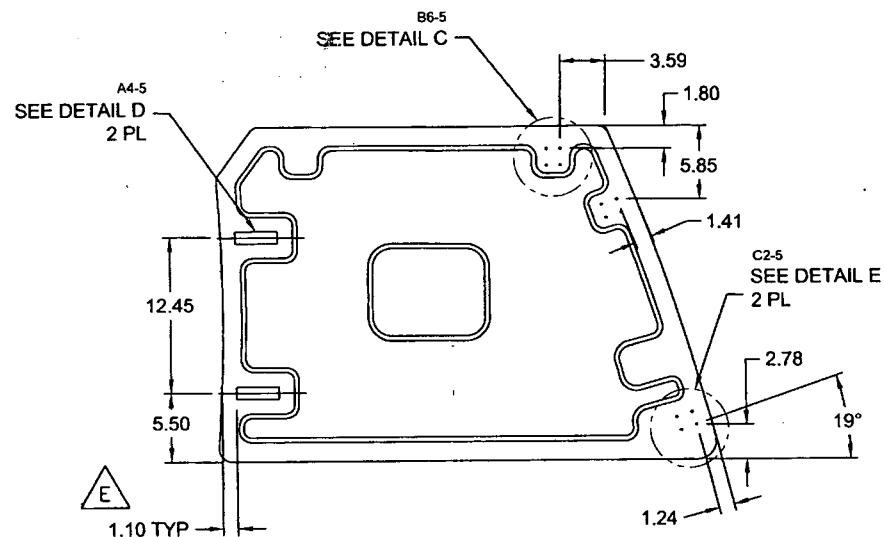


**D3186-1 SPACEPOD DOOR, LH**  
MAKE FROM D3186-1M

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 53071  
BL09-10-22

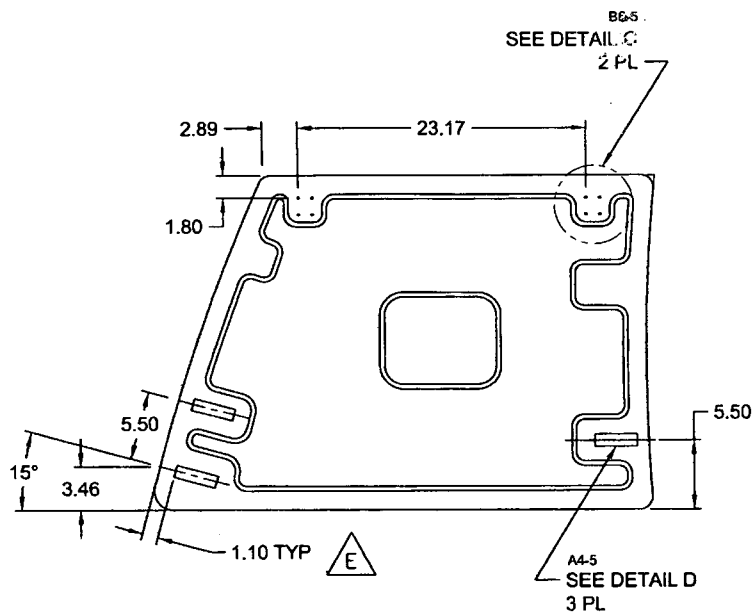


**D3186-3 SPACEPOD DOOR, LH**  
MAKE FROM D3186-1M

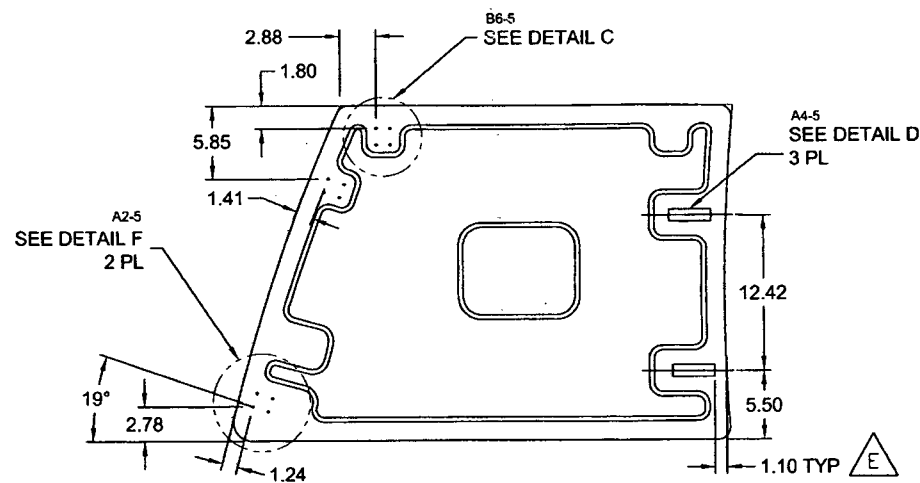
**RELEASED**  
2009-09-09

REV.	DESCRIPTION	BY	DATE
E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.88 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. D3186 TITLE SPACEPOD DOOR SCALE NTS  <small>COPYRIGHT © 2003 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	RF		
CHECKED	JP		
MFG. APPR.	AD		
APPROVED	AD		
DE APPR.	AD	REV. E SHEET 1 OF 5	
DATE	09.07.08		

53071



**D3186-2 SPACEPOD DOOR, RH**  
MAKE FROM D3186-2M



**D3186-4 SPACEPOD DOOR, RH**  
MAKE FROM D3186-2M

**RELEASED**  
2009-09-09

**NOTES:**

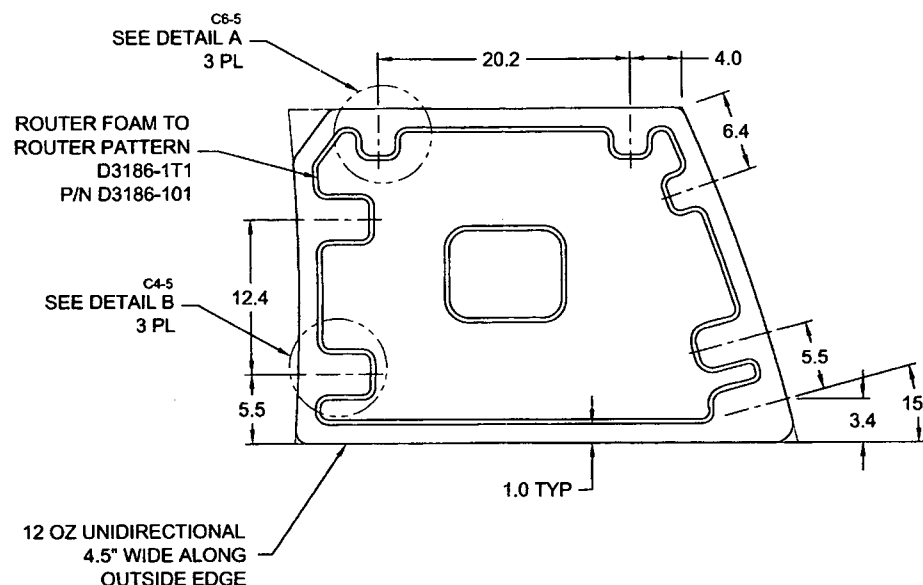
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
DATE	09.07.08	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



53071

MAIN LAYUP  
9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY



**D3186-1M SPACEPOD DOOR AS MOLDED**

**NOTES:**

**1) MATERIAL:**

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40  
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL  
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
LAMINATE PER DART QSI 006 4.0  
LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

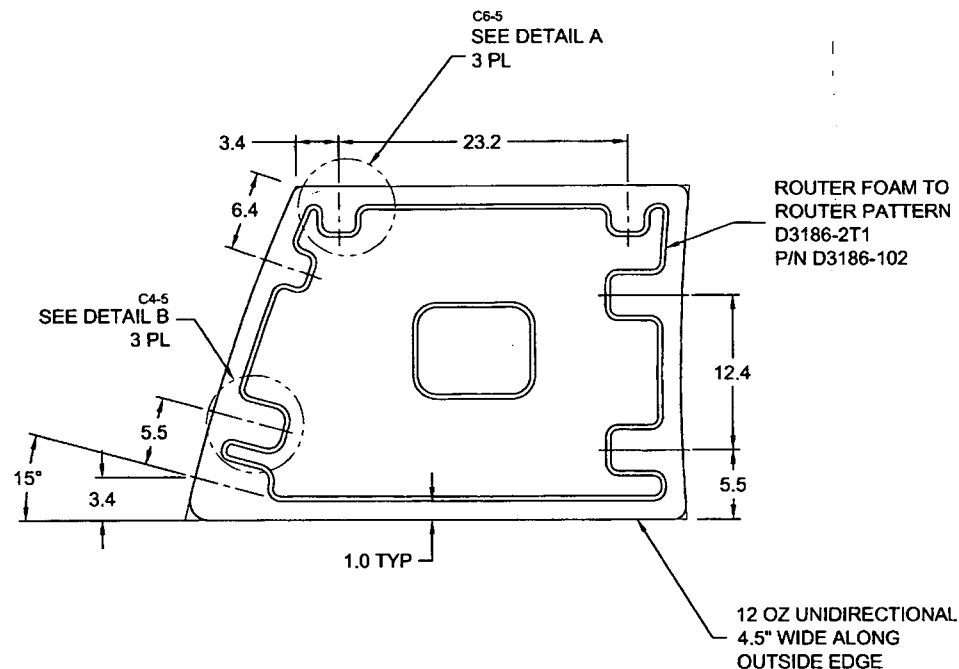
8) USE MOLD DT8005 FOR DOOR LAYUP

**RELEASED**  
2009-08-09

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
DATE	09.07.08	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

# MAIN LAYUP

9 OZ SATIN (9 SQ FEET)  
 9 OZ SATIN (9 SQ FEET)  
 FOAM  
 9 OZ SATIN (9 SQ FEET)  
 12 OZ UNIDIRECTIONAL  
 9 OZ SATIN (9 SQ FEET)  
 RESIN (35-45% BY WEIGHT)  
 PEEL PLY



## NOTES:

### 1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERA KANE 470-36/411/510A40  
 FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL  
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
 LAMINATE PER DART QSI 006 4.0  
 LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

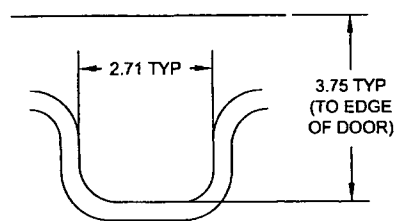
8) USE MOLD DT8006 FOR DOOR LAYUP

## D3186-2M SPACEPOD DOOR AS MOLDED

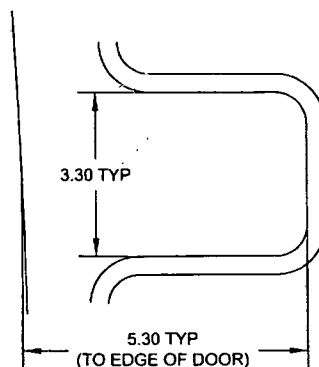
**RELEASED**  
 2009-08-09  
*MD*

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

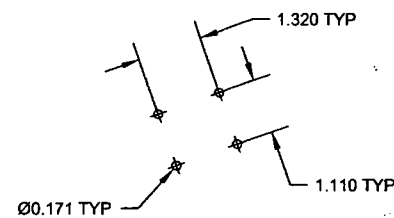
53071



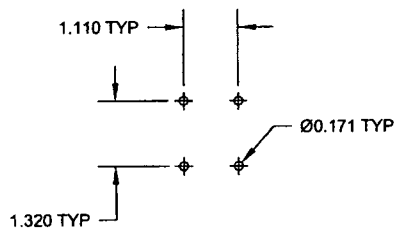
**DETAIL A** D6-3  
SCALE 4X D4-4



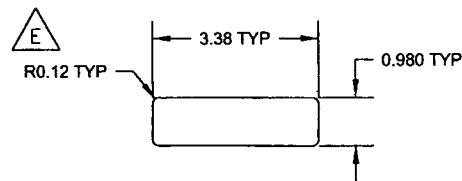
**DETAIL B** C6-3  
SCALE 4X C6-4



**DETAIL E** C1-1  
SCALE 4X

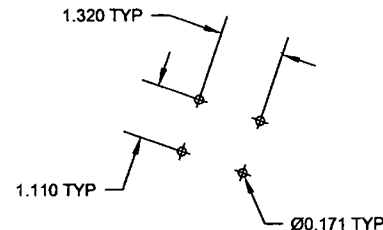


**DETAIL C** D7-1  
SCALE 4X D3-1  
D6-2  
D3-2



NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D** C5-1  
SCALE 4X D4-1  
B6-2  
C2-2



**DETAIL F** C4-2  
SCALE 4X

**RELEASED**  
2009-09-09

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

## 5.0 PARTS LIST

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
X							D130-780-041	SPACEPOD™ LH, EC 130 B4
	X						D130-780-042	SPACEPOD™ RH, EC 130 B4
1		X					D130-780-043	DOOR ASSEMBLY, LH
	1		X				D130-780-044	DOOR ASSEMBLY, RH
1				X			D130-780-011	LH SLIDING DOOR HINGE KIT
1	1				X		D130-780-013	SWITCH RELOCATION KIT
				1		X	D130-780-015	CLOSEOUT KIT
2	2						D3815-041	WEB ASSEMBLY
3	3						D3815-5	PACKER
		1	1				D2589	KEYS, KEY CHAIN
1	1						D3837-1	DECAL
4	1						D3015-3	LOCK NUT
		1					D3186-3	SPACEPOD™ DOOR, LH
			1				D3186-4	SPACEPOD™ DOOR, RH
1							D3798-041	FLOOR
	1						D3798-042	FLOOR
1							D3188-5	SPACEPOD™ BODY
	1						D3188-6	SPACEPOD™ BODY
1	1						D3547-1	BRACKET
1	1						D3550-1	STRUT
		1	1				D3552-7	GAS SPRING
1	1						D3554-7	BALL STUD
4	4						AN3-3A	BOLT
4	4						AN3-6A	BOLT
2	2						AN3-10A	BOLT
1	1						AN5-5A	BOLT
38	38						AN525-10R7	SCREW
8	8						AN526C832R14	SCREW
6	6						MS24694S54	SCREW
7	7						MS24694S67	SCREW
1	1						MS24694S69	SCREW
		2	2				MS27039-0811	SCREW
8	8						A3235-020-935	WASHER
14	14						NAS1149D0363J	WASHER
16	16						NAS1149D0332J	WASHER
		4	4				NAS1149DN832J	WASHER
3	3						NAS1149D0563J	WASHER
		2	2				NAS1515H3	NYLON WASHER
		2	2				MS21042L08	NUT
22	22						MS21042L3	NUT (or MS21042-3)
1	1						MS21042L5	NUT
10	10						AKS7-1032-130	INSERT
28**	28**						AKS7-1032-130	INSERT
10	10						MS21059L3	NUTPLATE

• COPYRIGHT © 2008 BY DART AEROSPACE LTD. •  
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED  
 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: B

Date: 09.06.11

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
					2		D3819-1	MALE SPADE CONNECTOR
					2		D3597-1	FEMALE SPADE CONNECTOR
					1		D3598-2-096	EXPANDABLE SLEEVE
					24		D3599-1	TIE-WRAP
					24		D3600-1	TIE-WRAP MOUNT
					24 FT		M22759/41-22-9	WIRE
		1*	1*				D2464-1250	NEOPRENE SEAL
1**		1*					D3837-3	DECAL
	1**		1*				D3837-4	DECAL
		2*	2*				D2586	LATCH
		2*	2*				D2585	MOUNTING CHANNEL
		2*	2*				D2621	LATCH PLATE
		2*	2*				MS27039-1-15	SCREW
		2*	2*				NAS1149D0363J	WASHER
		2*	2*				MS21042L3	NUT (or MS21042-3)
		1*	1*				D2857-1	HINGE BRACKET
		1*	1*				D2857-2	HINGE BRACKET
		2*	2*				D2228	BACKING PLATE
		8*	8*				AN526C832R10	SCREW
		8*	8*				NAS1149DN832J	WASHER
		8*	8*				MS21042L08	NUT
		1*	1*				D3557-1	BRACKET
		2*	2*				D2228	BACKING PLATE
		1*	1*				D3554-7	BALL STUD
		1*	1*				NAS1149D0563J	WASHER
		1*	1*				D3015-3	LOCK NUT
		2*	2*				AN526C832R14	SCREW
		2*	2*				AN526C832R10	SCREW
		4*	4*				NAS1149DN832J	WASHER
		4*	4*				MS21042L08	NUT
2**	2**						D2237	STRIKER PLATE
4**	4**						MS20426AD4-5	RIVET
2**	2**						D3538-1	HINGE BRACKET
2**	2**						D2179	HINGE BRACKET PLATE
4**	4**						AN526C832R24	SCREW
4**	4**						NAS1149DN832J	WASHER
4**	4**						MS21042L08	NUT
				1			D3813-041	HINGE ASSEMBLY, UPPER DOOR
				1			D3813-043	HINGE ASSEMBLY, LOWER DOOR
				2***			D3518-3	ROD END

© COPYRIGHT © 2008 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: B

Date: 09.06.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
				2***			NAS509-6	NUT
				1			D3814-1	HINGE, UPPER AIRFRAME
				1			D3814-3	HINGE, LOWER AIRFRAME
				2			D3816-1	SPACER
				4			D3816-3	SPACER
				1			D3817-041	ANCHOR PLATE
				2			AN3-5A	BOLT
				3			AN3-7A	BOLT
				2			AN310-4	CASTLE NUT
				2			AN4-17	BOLT
				2			AN970-4	WASHER
				5			MS21042L3	NUT
				2			MS24665-212	COTTER PIN
				3			MS24694S46	SCREW
				8			NAS1149D0363J	WASHER
				2			NAS1149D0463J	WASHER
				1			D3552-7	GAS SPRING
				2			D3622-1	BALL STUD
				1			D3820-1	DOOR SUPPORT
				2			MS21042L5	NUT
				2			NAS1149D0563J	WASHER
				1			D3892-1	SEAL
						1	D3983-1	OUTER CLOSEOUT
						1	D3983-3	INNER CLOSEOUT
						1	D3983-5	HINGE CLOSEOUT
						1	D3983-047	CLOSEOUT ATTACHMENT
						1	D3983-9	SPACER
						2	AN525-10R6	SCREW
						1	AN525-10R24	SCREW
						1	NAS1149D0363J	WASHER
						1	MS21042L3	NUT

\* Pre-installed on D3186-3/-4 Spacepod™ Door

\*\* Pre-installed on D3188-5/-6 Spacepod™

\*\*\* Pre-installed on D3813-041/-043 Hinge Assemblies



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D130-780 REV. B OR LATER APPROVED REVISION  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D130-780 REV. 1 OR LATER ACCEPTED REVISION

REF. TCCA STC: SH93-88  
REF. FAA STC: SR00098NY  
REF. EASA.IM.R.S.01292

The purpose of this DSI is to provide an alternate door prop for the D130-780-011 LH Sliding Door Hinge Kit.

In service experience has shown that LH Sliding Doors may have significantly more weight associated with their installation due to executive style finishing versus the standard utility LH Sliding Door. This extra weight requires a more powerful door prop to operate the door.

For D130-780-011 at CHG 003, the D3552-7 door prop is replaced with a D3552-13 door prop as follows:

IS	-041	-042	-043	-044	-011	-013	-015	PART NUMBER	DESCRIPTION
					1			D3552-13	DOOR PROP

WAS	-041	-042	-043	-044	-011	-013	-015	PART NUMBER	DESCRIPTION
					1			D3552-7	DOOR PROP

Customers with D130-780-011 at CHG 002 or earlier, may procure the DSI 9502-011 kit to replace the D3552-7 door prop with a D3552-13 door prop as follows:

-011		
X	DSI 9502-011	REPLACEMENT DOOR PROP KIT
1	D3552-13	DOOR PROP

- 1) Remove the D3552-7 door prop from the ball studs
- 2) Install the D3552-13 per IIN-D130-780 and ICA-D130-780.
- 3) Update parts list in IIN-D130-780 and ICA-D130-780 to reflect the part number change.
- 4) Make an entry in the technical record of the aircraft indicating that DSI 9502 has been accomplished.

Weight and Balance change associated with this DSI is negligible.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	<i>[Signature]</i>
	D. SHEPHERD (DE # 02)
DATE:	10.02.03
CERT. NO.:	SH93-88
ISSUE NO.:	6

A	NEW ISSUE	<i>[Signature]</i>	10.02.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9502	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	REPLACEMENT DOOR PROP	NTS
DATE	10.02.03	COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries